

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-005764**Date Inspected:** 12-Mar-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Shen Fuyou/Yu Dong Ping**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG segments, cross beams and suspension b**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Steve Hall was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

OBG assembly bay 14

This QA observed ZPMC qualified welding personnel identified as Mr. Jin Zhenghu (037907) and Mr. Dai Xicheng (066012) perform FCAW welding on welds joining diaphragms to U-rib deck panels. Deck panel is identified as DP546-001. ZPMC QC identified as Mr. Zhang Xiao Ming was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2133.

This QA observed ZPMC qualified welding personnel identified as Miss Wang Min (048296) perform SAW welding on weld joint identified as SEG042A-009. ZPMC QC identified as Mr. Zhang Xiao Ming was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2221-B-L2c-S-2.

This QA observed ZPMC qualified welding personnel identified as Mr. Wang Chang Ming (047864) perform SMAW welding on weld joint identified as SEG029A-004. ZPMC QC identified as Mr. Wu Bin was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2214-B-U2.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

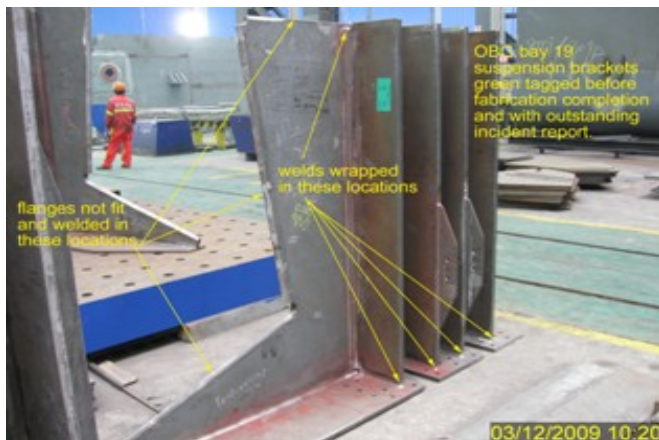
OBG assembly bay 19

This QA observed ZPMC personnel fitting diaphragms to deck plates for cross beam assembly identified on the material as CB3.

This QA observed ZPMC QC Magnetic particle Testing (MT) technicians examining stiffener to bottom plate fillet welds on bottom panel identified on the material as BP025-002. QA noted that MT technician has marked several indications on these welds to be ground.

This QA was approached by two American Bridge Fluor (ABF) inspectors and asked to sign off on four green tags for the following suspension brackets: SB14E, SB14W, SB16E and SB16W. This QA noted that the fabrication of these suspension brackets appear to be incomplete. There also appears to be an outstanding incident report concerning wrapped welds at the stiffener ends. This QA issued the incident report on Feb. 22, 2009. This QA contacted Caltrans QA task leader to inquire about the status of these components. The task leader instructed this QA not to sign the green tag documents at this time under the direction of Caltrans Structural Materials Representative (SMR). This QA observed ABF inspectors put the green tags on these components without Caltrans signature on the green tag documents.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



Summary of Conversations:

As mentioned above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Patrick Lowry (858)-344-2712, who represents the Office of Structural Materials for your project.

Inspected By:	Hall,Steven	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
